



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3628-1

Job Sheet 169213



Part No: D3628-1

Job Qty: 250 ea

Part Name: Washer, Cupped



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/5/17

Job Tracking No:

Due Date: 1/8/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C IPP Rev:A New Issue 07-05-28 JLM IPP Rev:B Removed Powder 07-07-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
100	Purchasing	250 pcs		1/8/18	0.00	0.00	Purchasing			Sign-off
110	Packaging	250 pcs		1/8/18	0.00	0.00	Packaging2			38
120	QC	250 pcs		1/8/18	0.00	0.00	QC6			38
130	Packaging	250 pcs		1/8/18	0.00	0.00	Packaging3-1	5/044		38
140	QC21-SA	250 Ea		1/8/18	0.00	0.00	QC21			38

Part Op 100 - Issue P/O: D36549 Email or Ship DXF file to vendor Laser Cut D3628-1 flat pattern and form as per Dwg
Descriptions: D3628 Possible Supplier: GFI

110 - Ensure material certification is attached

DEC 06 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D3628-1P	250	0	0	0

Part Specifications

Specifications could not be found.

Plex 12/5/17 9:15 AM dart.lavoie.chantal

DART
AEROSPACE
S034982

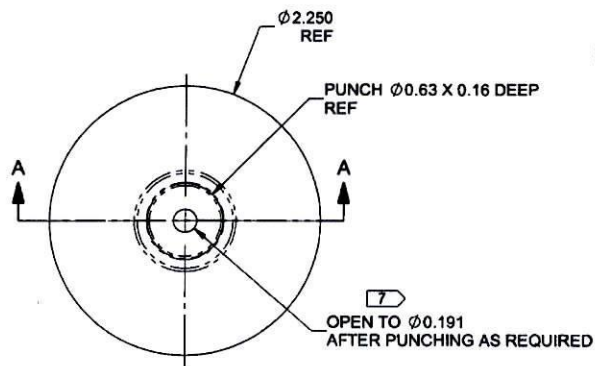
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



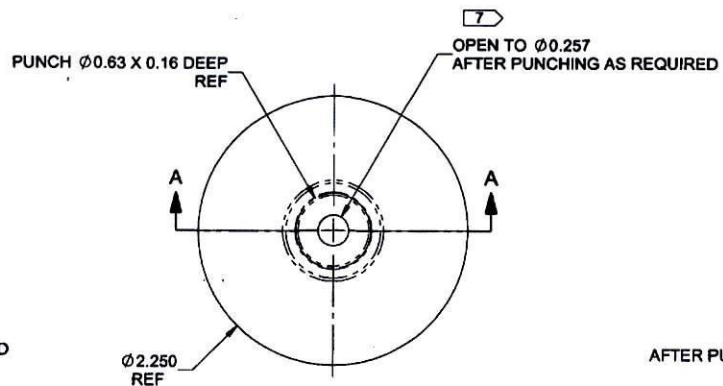
Washer, Cupped

PART NO: D3628-1
Original Serial #: S034982
Revision:
Operation: Purchasing
Change No:

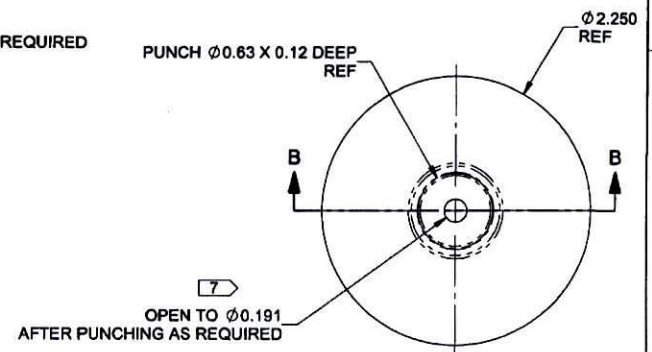
Mfg Date: 01/24/18 Job No: 169213
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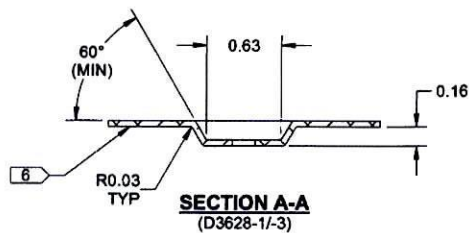
D3628-1 CUPPED WASHER



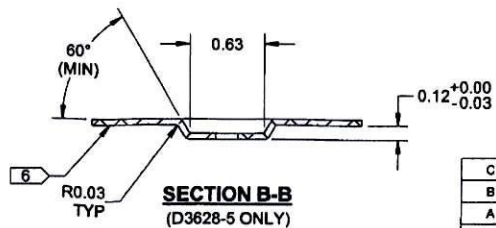
D3628-3 CUPPED WASHER



D3628-5 CUPPED WASHER



SECTION A-A
(D3628-1/-3)



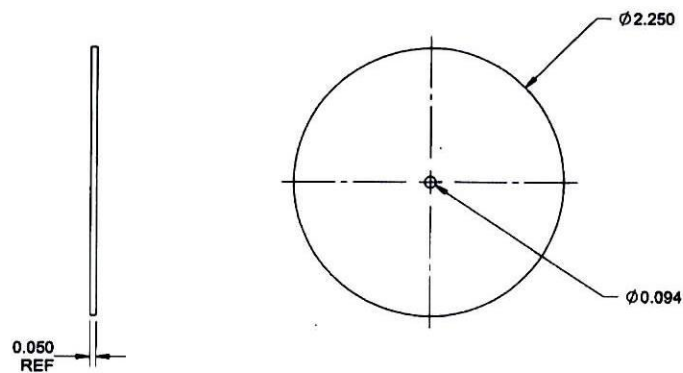
SECTION B-B
(D3628-5 ONLY)

NOTES:

- 1) MATERIAL: MADE FROM D3628-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.5
- 7) WHEN DRILLING OUT THE CENTRE HOLE AFTER PUNCHING, ENSURE THAT THE HOLE IS DRILLED CONCENTRIC TO THE CUPPED AREA, WITHIN 0.03
- 8) WEIGHT: 0.02 lbs

RELEASE
2012-05-07

C	UPDATE DWG TO CURRENT STD; ADD -5, ZN C1-1.	DC	12.04.19
B	REMOVE POWDER COAT	CB	07.07.09
A	NEW ISSUE	CB	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D3628	SHEET 1 OF 2
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CUPPED WASHER	NTS
DATE	12.04.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3628-1F FLAT PATTERN

RELEASED
2012-05-07
WPD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
ANNEALED, 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	EE	DRAWING NO.	REV. C
MFG. APPR.	EE	D3628	SHEET 2 OF 2
APPROVED	NO	TITLE	SCALE
DE APPR.	WPD	CUPPED WASHER	NTS.
DATE	12.04.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited



BON DE LIVRAISON /SHIPPING MEMO

DATE DE LIVRAISON/SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO.	PAGE
JR - DY	MO - MO	AN. - YR		
16	01	18	0613515	1/1



VENDU À /SOLD TO

EXPÉDIÉ À /SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
DART GFI-0299		0342720	PO038549	
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.		DESCRIPTION	
250	D3628-1P		CUPPED WASHER	
			ITEM 2	
			C OF C REQ'D	
	MFG. JOB# 0336126 - 001 50 pcs			
	0342720 - 001 QTY 200 pcs			
	DUE DATE: 19 January 2018			

EXPÉDITEUR
SHIPPER

REÇU PAR /RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038549

Supplier: GFI001-VC
GFI
180 Avenue Labrosse
Pointe Claire
QC
H9R 1A1 Canada
Phone: 514 630 4877
Fax: 514 630 4849

PO No: PO038549

PO Date: 12/4/17

Due Date: 1/19/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

DEC 06 2017

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: COD

Freight Terms:

Special Comments:

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3602-1P			Angle As Per Dwg D3602 Rev. B	Firmed	1/19/17	30 pcs	0 pcs	30 pcs	\$39.50/pcs	\$1,185.00
2	D3628-1P			Cupped Washer As Per Dwg D3628 Rev. C	Firmed	1/19/18	250 pcs	0 pcs	250 pcs	\$2.72/pcs	\$680.00
3	D3484-041P			Tail Light Fairing As Per Dwg D3484 Rev.F	Firmed	1/19/18	10 pcs	0 pcs	10 pcs	\$356.00/pcs	\$3,560.00
4	D3484-042P			Tail Light Fairing As Per Dwg D3484 Rev. F	Firmed	1/19/18	10 pcs	0 pcs	10 pcs	\$356.00/pcs	\$3,560.00

Grand Total: \$8,985.00

Order Notes

DWG REV B

JAN 24 2018

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 12/7/17 8:11 AM dart.baker.diane



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038549

Supplier: GFI001-VC
GFI
180 Avenue Labrosse
Pointe Claire
QC
H9R 1A1 Canada
Phone: 514 630 4877
Fax: 514 630 4849

PO No: PO038549

PO Date: 12/4/17

Due Date: 12/15/17

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: COD

Freight Terms:

Special

Comments:

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3602-1P			Angle As Per Dwg D3602 Rev. B	Firmed	12/19/17 01/19/2018	30 pcs	0 pcs	30 pcs	\$70.00/pcs 39.50	\$2,100.00
2	D3628-1P			Cupped Washer As Per Dwg D3628 Rev. C	Firmed	12/19/17 01/19/2018	250 pcs	0 pcs	250 pcs	\$2.40/pcs 2.72	\$604.00
3	D3484-041P			Tail Light Fairing As Per Dwg D3484 Rev.F	Firmed	12/19/17 01/19/2018	10 pcs	0 pcs	10 pcs	\$280.00/pcs 356.00	\$2,800.00
4	D3484-042P			Tail Light Fairing As Per Dwg D3484 Rev. F	Firmed	12/19/17 01/19/2018	10 pcs	0 pcs	10 pcs	\$280.00/pcs 356.00	\$2,800.00
Grand Total:											\$8,304.00

Order Notes

DWG REV B

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A043 RETENTION OF QUALITY DOCUMENT

APPROVED

By Pedro at 4:36 pm, Dec 06, 2017

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 12/6/17 11:14 AM dart.baker.diane

JAN 24 2018

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 21 OUR JOB NO 0342720-001 SHIPPING MEMO 0613515

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>2</u>	<u>250 PCS</u>	<u>PO038549</u>	<u>D3628-1P</u>	<u>C</u>	<u>CUPPED WASHER</u>	<u>C</u>
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
<u>AMS 5513 304 ANN</u>		<u>TW METALS / NORTH AMERICAN STAINLESS</u>			<u>H/N 235W</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER 0336126-001 (50 PCS) AND 0342720-001 (200 PCS).</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 16 JANUARY 2018

G.F.I. Q.C. REP. [Signature]





CERTIFICATIONS

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under statutes including federal law. Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

TW Metals certifies that the supplies furnished under this contract contain no metallic mercury or mercury compounds, and have not come in contact with mercury or alpha bearing instruments while in the possession of TW Metals Inc.

Customer Name: BFI, Inc

Purchase Order No.: 0089253

Item number: 0002

Shipper/Invoice No.: 12107120

Material: 304

Manufacturing Mill: NA-S

Specification: Ams 5573

Heat / Lot No. 235W

Size: 050

Quantity: 1 pc

Signature: Jarice Clark

Date: 5/16/17



United Performance Metals

Customer Name: TW Metals - NY

Customer PO: D12017724

UPM Sales Order: 627379

Date: 11/05/2017

Description/Form: STAINLESS 304L - SHEET

Heat Number: 235W

Ingot: 02235W A

Width: 48.0000 Length: 120.0000

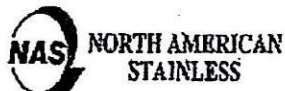
Size: 0.05000

Customer P/N:

Packing List Number: 23690-1

Quantity: 82 lb. 1 pc.

Paul Drake
Quality Associate



METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 248146 01 Mail To: UNITED PERFORMANCE METALS 3475 STAGES ROAD HAMILTON, OH 45015
Customer: 0018 001 Ship To: UNITED PERFORMANCE METALS 3475 STAGES ROAD HAMILTON, OH 45015
Date: 12/20/2016 Page: 1
Steel: 302/304/304L

Finish: 2B

Your Order: M01030146

NAS Order: AN 0730596 01

Corrosion: ASTM A262/15, 1803end-0X

PRODUCT DESCRIPTION:

S/S COIL, C.R. ANNEALED & PICKLED; UNS 30408/30403/30200
ASTM A240/15b, A480/15, A566/15; ASME SA240/15, SA480/15, SA566/15
CHEM ONLY ON FOLLOWING ASTM: A276/16, A479/16, A484/15, A312/16
CHEM ONLY ON FOLLOWING ASME: SA312/13, SA479/13
AMS 5511B/5513J/5516P XTR; MIL-S-5059D ARMB (X CN REAS); MIL-1043B
NACE MR0175/ISO 15156-3:2009 A, MR0103/07; Q98756D-A X HAZ PERN
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED
PMT 304L/304/302; AMS 5511H

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DPAAS Compliant

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
02235W A	02235W A	.0500	48.0000	15,830	COIL	2392.0	1	1 00624

Lab Accreditation Bureau, ISO/IEC 17025, Certificate# 62323

CHEMICAL ANALYSIS CM(Country of Italy) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/14a

HEAT	CH	C %	CR %	CU %	NI %	EO %	N %	MI %	P %	S %
235W	US	.0155	18.1390	.3465	1.6175	.2785	.0911	0.0560	.0290	.0018
SI %										
.2520										

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d b f c =	UTS XSI	20C .2% YSI	20C ELONG % 2"	Hard RB	Tail Hard	Grain No.	D Per P.N.	UNREC
02235W A	02235W A	Y T	94.77	43.79	58.82	82.00	85.00	9.00	7.52	As per request
By: <i>[Signature]</i>										
Spec ALL										
Pages 1 Date: 12/20/2016										

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

KRIS LARE

12/20/2016





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038549

Supplier: GFI001-VC
GFI
180 Avenue Labrosse
Pointe Claire
QC
H9R 1A1 Canada
Phone: 514 630 4877
Fax: 514 630 4849

PO No: PO038549
PO Date: 12/4/17
Due Date: 12/15/17
Purchase Order Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: COD
Freight Terms:
Special Comments:

Items

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2	D3628-1P			Cupped Washer As Per Dwg D3628 Rev. C	Firmed	XXXXXX 01/19/2018	250 pcs	0 pcs	250 pcs	\$2400.00 2.72	\$604.00
3	D3484-041P			Tail Light Fairing As Per Dwg D3484 Rev. F	Firmed	XXXXXX 01/19/2018	10 pcs	0 pcs	10 pcs	\$280.00 356.00	\$2,800.00
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Order Notes

DWG REV B

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A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

APPROVED

By Pedro at 4:36 pm, Dec 06, 2017

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS